

# Work Order ID 60625

Thursday, July 15, 2010 10:28:40 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

*[Signature]*

Date:

*10-7-13*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3914

A

100

Weld per dwg A/R S.S. rod Batch: *M113328* 0.00



Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D3914 using DT9607A  
2- weld hinge (3) and Mounting brackets as per dwg D3914  
\*\*\*inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D3914  
\*\*\*make sure to place mesh correctly on lid, check with label plate before  
tacking mesh\*\*\*

*[Signature]* 10/07/21 (1x)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

*[Signature]* 10.07.22

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

**Work Order ID 60625**

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Page 2

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Setup Start

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Stop

Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010 Start Qty: 1.00

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Required Date: 7/22/2010 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

0.00

8/10/07/26

(H)

QC

Memo

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

0.00

M 112588

Memo

\*\*\* mask sides of hinge prior to powdercoat\*\*\*

Start Time: 9:25

Oven Temperature: 320°

Finish Time: 9:55

① BL 10-7-28

Powdercoat

Powder Coating

140

Wing Walk as per dwg QSI005 4.4 Batch M 1144200

0.00

Memo

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

E/S 10/07/27 ①

HandFinish

Hand Finishing

W/O:		WORK ORDER CHANGES						
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Required Date: 7/22/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

*Ep 50/07/27 @*

160

Identify as per dwg & Stock Location: *6-A*

0.00

Packaging

Memo

0.00

Packaging

*w/o 360620**Ep 50/07/27 @*

170

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

*10/07/27 @*  
*DL 10-7-27*

W/O:		WORK ORDER CHANGES						
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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 15, 2010 10:28:44 AM

Page 1

Work Order ID: 60625

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010


Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581		Manufactured	No			100	Each	13.0000	2	2			
													
Mounting Bracket													

Location

Loc Qty

Loc Code

WA

13

46086

2

51745


1

57185

1

59265

9

D3914-1		Manufactured	No			100	Each	6.0000	2	2			
													
Rib													

Location

Loc Qty

Loc Code

WA


6

59295

2

59926

4

D3914-7		Manufactured	No			100	Each	6.0000	2	2			
													
Rib													

Location

Loc Qty

Loc Code

WA

6

59095

2

59986

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Thursday, July 15, 2010 10:28:44 AM

Page 2

Work Order ID: 60625

Parent Item: D3914-041


Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00


Required Qty: 1.00

✓ D4016-3 Manufactured No 100 Each 7.0000  
  
 Hinge Half, Lid



3  
 3  
 SJ 10/07/20


Location	Loc Qty	Loc Code
WA	7	
58737	1	
59744	6	

✓ D4018-5 Manufactured No 100 Each 48.0000  
  
 Rib



3  
 9  
 SJ 10/07/20


Location	Loc Qty	Loc Code
WA	48	
58669	12	
59929	36	

✓ D4020-5 Manufactured No 100 Each 2.0000  
  
 Mesh (350 Basket Long, Lid)



3  
 6  
 1  
 SJ 10/07/20

Location	Loc Qty	Loc Code
WA	2	
59601	2	

✓ D4021-3 Manufactured No 100 Each 4.0000  
  
 Data Plate



①  
 1  
 B60547 ① SJ 10/07/20

Location	Loc Qty	Loc Code
WA	4	
56050	1	
59054	1	
59987	2	

Thursday, July 15, 2010 10:28:44 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, July 15, 2010 10:28:44 AM

Page 3

Work Order ID: 60625

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 7/15/2010

Required Date: 7/22/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-041

Manufactured No

100 Each 3.0000



Lid Rib Assembly, Fwd (350 Basket)

Location

Loc Qty

Loc Code

WA

3

59414

1

60045

2

Manufactured No

100 Each 3.0000

✓ D4035-043



Lid Rib Assembly, Aft (350 Basket)

Location

Loc Qty

Loc Code

WA

3

59415

1

60047

2

Manufactured No

140 Each 0.0000

D2728-3



Dart Logo label

D4086-210



Placard, Max Load

Manufactured No

140 Each 9.0000

Location

Loc Qty

Loc Code

ST117

9

58926

9

10/07/20

10/07/20

10/07/27

10/07/27

Thursday, July 15, 2010 10:28:44 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

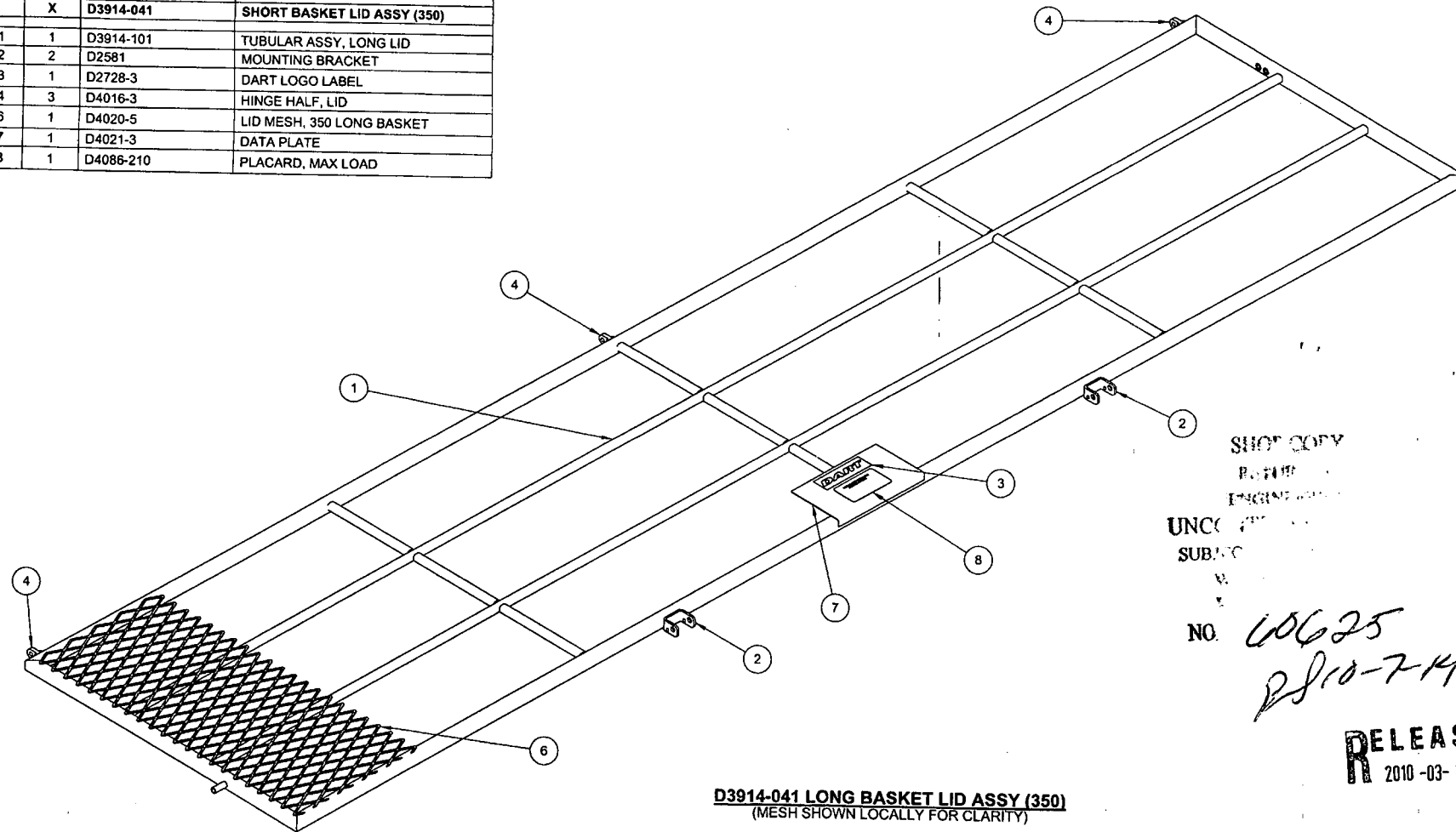
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**NOTE:** Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHORT COPY  
P. 1111  
ENGINEERING  
UNCLASSIFIED  
SUBJECT

NO. 60625  
2810-714

**RELEASED**  
2010-03-22

A		NEW ISSUE		JPH	10.03.16
REV.		DESCRIPTION		BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3914 TITLE LONG BASKET LID ASSY (350) SCALE NTS		REV. A	
DRAWN	JPH			SHEET 1 OF 4	
CHECKED					
MFG. APPR.					
APPROVED					
DE APPR.					
DATE		10.03.16			

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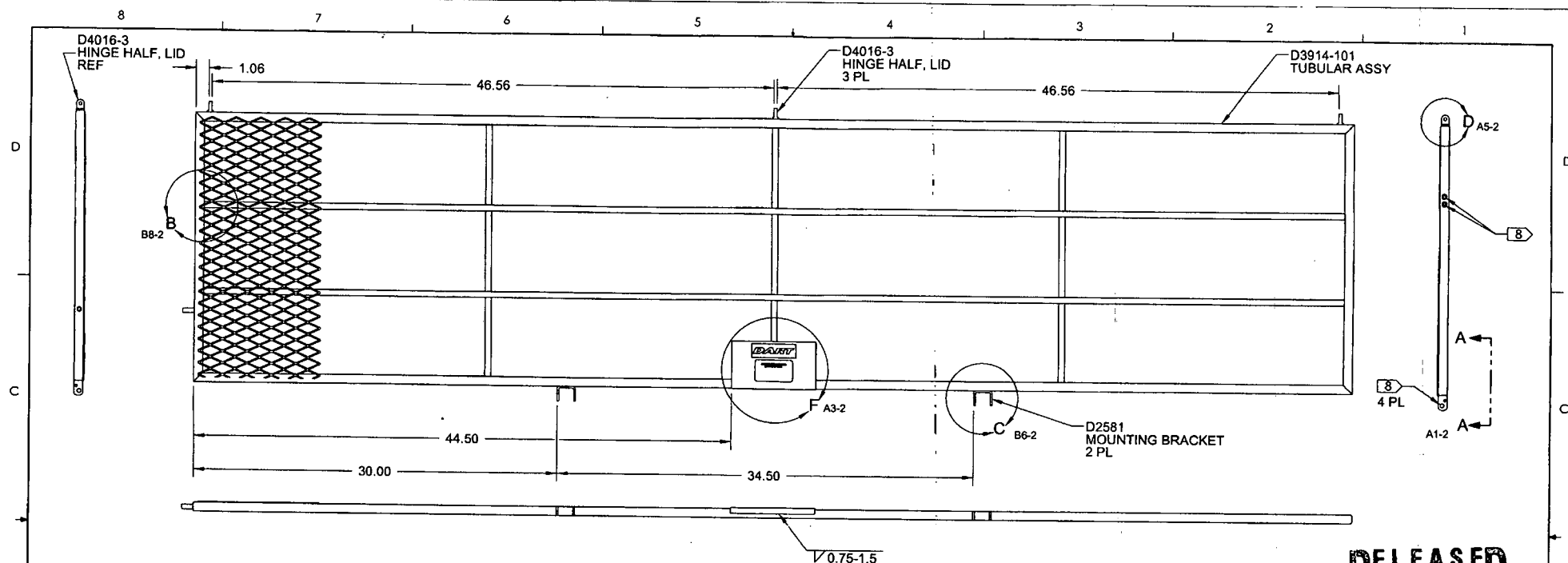
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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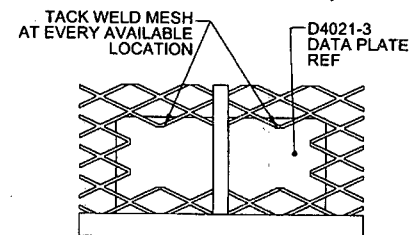
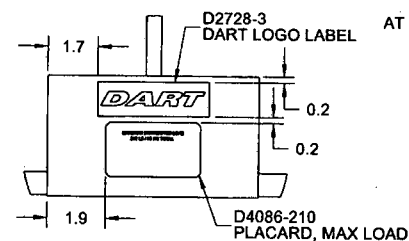
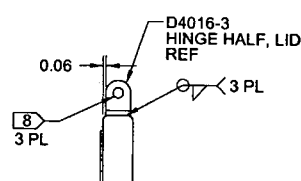
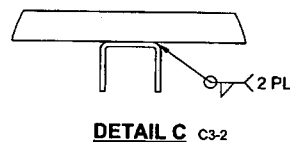
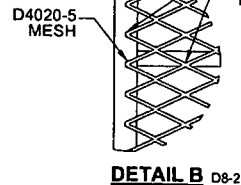
**NOTE:** Date & initial all entries



**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)





**RELEASED**  
2010-03-22

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION



- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 22.35 lbs APPROX
  - 8) MASK HOLES PRIOR TO FINISHING
  - 9) WELD PER DART QSI 004

*WLB 00025*

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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**NOTE:** Date & initial all entries

ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT

D

C

B

A

D4035-041  
RIB ASSY, FWD

TYP

E C2-3

TYP

D4035-043  
RIB ASSY, AFT

22.50

6.87  
TYP

TYP

D3914-1  
RIB  
2 PLD4018-5  
RIB  
9 PLD3914-7  
RIB  
2 PL23.25  
TYP

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

8 D3914-101 TUBULAR ASSY, LONG LID

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 3 OF 4
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RELEASED  
2010-03-22  
APD

D

C

B

A

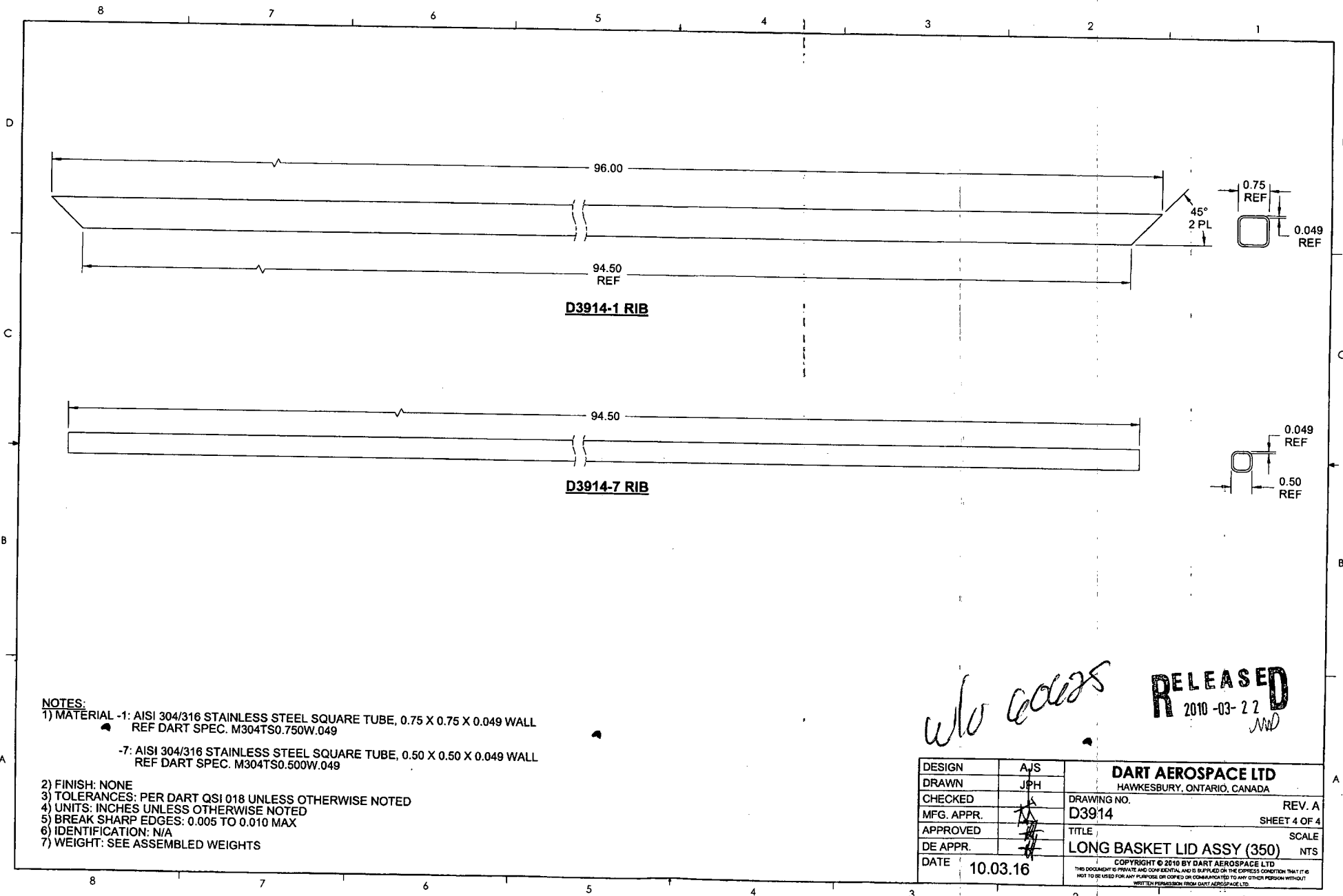
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**NOTE:** Date & initial all entries



**NOTES:**

1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: N/A

7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3914	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LONG BASKET LID ASSY (350)	NTS
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**RELEASED**  
2010-03-22  
*MD*

*who orders*

W/O:		WORK ORDER CHANGES					
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